



### Coated Electrode for Hardfacing Applications



## General Description

PHILARK PH 350 R is an electrode specially designed for low-alloy steels with a tensile strength up to 900 N/mm<sup>2</sup> and the reclamation of the parts subjected to metal-to-metal friction under high pressure. The readily machinable deposit gives an alloy steel providing high mechanical properties and can be machined. It is also suitable for applications where resistance to deformation during service is required for maximum operational life.

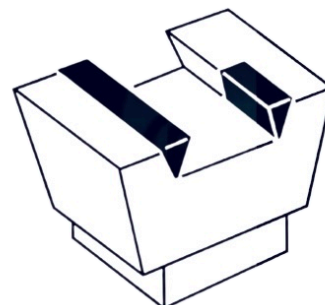
Pressure	✓	✓	✓	✓	✓
Crack Resistance	✓	✓	✓	✓	✓
Machinability	✓	✓	✓	✓	✓
Impact	✓	✓	✓	✓	✓
Mechanical Strength	✓	✓	✓	✓	✓

## Mechanical Properties of Weld Metal

Compressive Strength: 170 kg/mm<sup>2</sup>  
Tensile Strength : 92-96 kg/mm<sup>2</sup>  
Yield Strength : 76-80 kg/mm<sup>2</sup>  
Elongation (L=5d) : 12-16 %  
Hardness : 300-360 HB (as welded)

## Typical Applications

- Rollers
- Forging dies
- Forming dies
- Anvil dies
- Anvil guides of power hammer
- Hammers
- Table rollers
- Turbine blades
- Cushion layers before hardfacing



## Anvil Guides Power Hammer Guides

## Welding Parameters

Current Type and Polarity : DC(+)

Diameter [ mm ]	3.15	4.0
Length [ mm ]	350	350
Current [ A ]	80-135	135-180

## PHILARK ALLOYS

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